

Work Order ID 127705

127705

Page 1

Item ID: D206-781-151KIV

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Vertical Tunnel-Ivory

Stop ***NS2***

Start Date: 12/12/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-12-23

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-781	D								
100	Document Control	0.00							
100									
DC									
Doc.Control -USB or Paperwork									
	Memo	0.00							
	Photocopy bluefile & type labels per PPP D206-781-151KIV (CHG 001)								
110	Pick Kit	0.00							
110									
Packaging									
Packaging	Memo	0.00							
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC									
Quality Control	Memo	0.00							

MLJ 15-02-23

DAS
46
9-89
MAR 03 2015

DAS
27
9-89

FEB 23 2015
DAS
28
9-89

(1x)

DAS
46
9-89
MAR 03 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127705

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127705

Page 2

Item ID: D206-781-151KIV

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Vertical Tunnel-Ivory

Stop

NS2

Start Date: 12/12/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-781-151KIV

Location: EG 118

PPP rev

/XDAS
28
9-89

MAR 04 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MJ15-03-05MF
15-3-4

DQA: _____ Date: _____



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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____
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Picklist Print

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Page 1

Work Order ID: 127705

127705

Parent Item: D206-781-151KIV

D206-781-151KIV

Parent Item Name: Vertical Tunnel-Ivory

Start Date: 12/12/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add ALS4-632-130 11/02/15 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4632-130 *AI-S4632-130* insert		Purchased	No				Each	998.0000	**	8		DAS 27 9-89 FEB 23 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST550	118908			998					DAS 28 9-89
								998					
ALS4-632-80 *AI-S4-632-80* Insert		Purchased	No				Each	64.0000	**	8		DAS 27 9-89 FEB 23 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST550	130822			64					DAS 28 9-89
								64					
								f					
D3800-1-100 *D3800-1-100* Hook And Loop Strip (1" Soft)		Manufactured	No					300.0000	**	14		DAS 27 9-89 FEB 23 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST419	124095			300					DAS 28 9-89
								300					
								f					
D3800-3-100 *D3800-3-100* Hook And Loop Strip (1" Hard)		Manufactured	No					75.0000	**	14		DAS 27 9-89 FEB 23 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST419	124096			75					DAS 28 9-89
								75					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Page 2

Work Order ID: 127705

127705

Parent Item: D206-781-151KIV

D206-781-151KIV

Parent Item Name: Vertical Tunnel-Ivory

Start Date: 12/12/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

D3822-1KIV Manufactured No

Each 0.0000

D3822-1KIV

DAS
46

Vertical Tunnel, LH-Ivory

B127487 **

DAS
27

DAS
28

D3822-2KIV Manufactured No

Each 0.0000

D3822-2KIV

DAS
46

Vertical Tunnel, RH-Ivory

B127427 **

DAS
27

DAS
28

D3822-3KIV Manufactured No

Each 0.0000

D3822-3KIV

DAS
46

Vertical Tunnel Aft Center

B127479 **

DAS
27

DAS
28

D3822-5KIV Manufactured No

Each 1.0000

D3822-5KIV

DAS

Vertical Tunnel, Top-Ivory

**

FEB 23 2015

DAS
27

DAS
28

9-89

Location

Loc Qty

Loc Code

ST427

1

95128

1

B127595

Each

0.0000

1

FEB 23 2015

DAS
27

DAS
28

9-89

D3822-7KIV Manufactured No

Each

D3822-7KIV

DAS
46

Vertical Tunnel, Lower

B127509 **

DAS
27

DAS
28

NAS388-6-12P Purchased No

Each 51.0000

NAS388-6-12P

DAS

SCREW

**

FEB 23 2015

DAS
27

DAS
28

9-89

Location

Loc Qty

Loc Code

ST264

51

m127580

51

Each

22.0000

4

FEB 23 2015

DAS
27

DAS
28

NAS388-6-8P Purchased No

NAS388-6-8P

DAS

SCREW

**

FEB 23 2015

DAS
28
9-89

9-89

Location

Loc Qty

Loc Code

ST264

22

m130820

22

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Shop Packet Print

Page 2

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Page 3

Work Order ID: 127705

127705

Parent Item: D206-781-151KIV

D206-781-151KIV

Parent Item Name: Vertical Tunnel-Ivory

Start Date: 12/12/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

NAS391B6P

Purchased

No

Each

69.0000

(18)

NAS391B6P

DAS

**

Washer

46

9-89

Location

Loc Qty

Loc Code

ST263

69

m130799

69

m131348

V

7

DAS
27

FEB 23 2015

DAS
28
9-89

DQA: _____ Date: _____



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